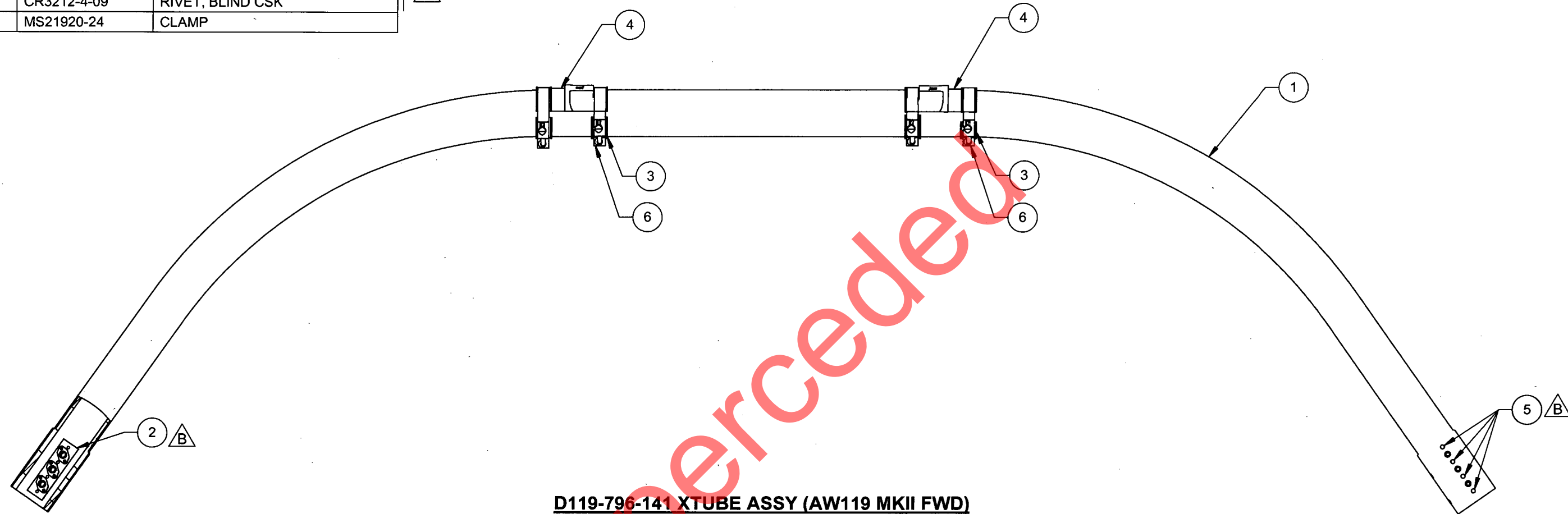


ITEM	QTY -141	P/N	DESCRIPTION
	X	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141BND	CROSSTUBE, FWD
2	4	D2873-043	NUT PLATE ASSEMBLY
3	4	D5123-3	CLAMP CUSHION
4	2	D5124-1	FWD SUPPORT
5	16	CR3212-4-09	RIVET, BLIND CSK
6	4	MS21920-24	CLAMP



D119-796-141 XTUBE ASSY (AW119 MKII FWD)

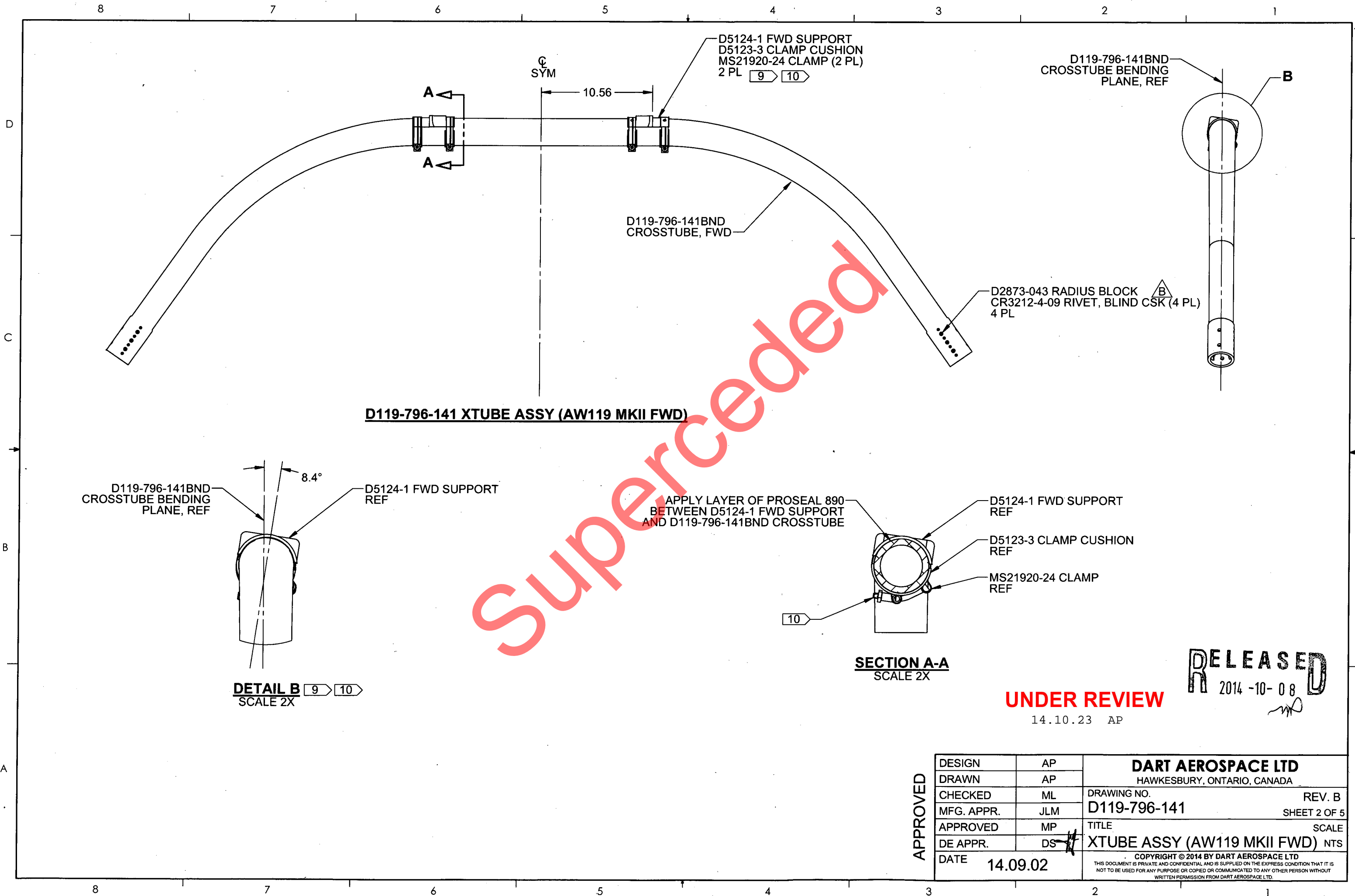
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-141" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 18.10 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) ABRASE MATING SURFACES OF D5124-1 FWD SUPPORTS AND CROSSTUBE WITH 180 GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.100 MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5124-1 FWD SUPPORTS AND INSTALL AT AN 8.4° OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL THE MS21920-24 CLAMPS AND D5123-3 CLAMP CUSHIONS WHILE WET.
- 10) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY, THE NUT IS FACING AFT AND HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

UNDER REVIEW
14.10.23 AP

RELEASED
2014-10-08
mw

B	ADDED D2873-043 RADIUS BLOCK, CR3212-4-09 RIVETS, ADDED SKIDTUBE REFERENCE FOR LOCATING CUFF HOLES. RE-ORGANIZED NOTES AND REMOVED REDUNDANT INFORMATION	AP	14.09.02
A	NEW ISSUE	AP	14.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D119-796-141	SHEET 1 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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D119-796-141 XTUBE ASSY (AW119 MKII FWD)

DETAIL B 9 10
SCALE 2X

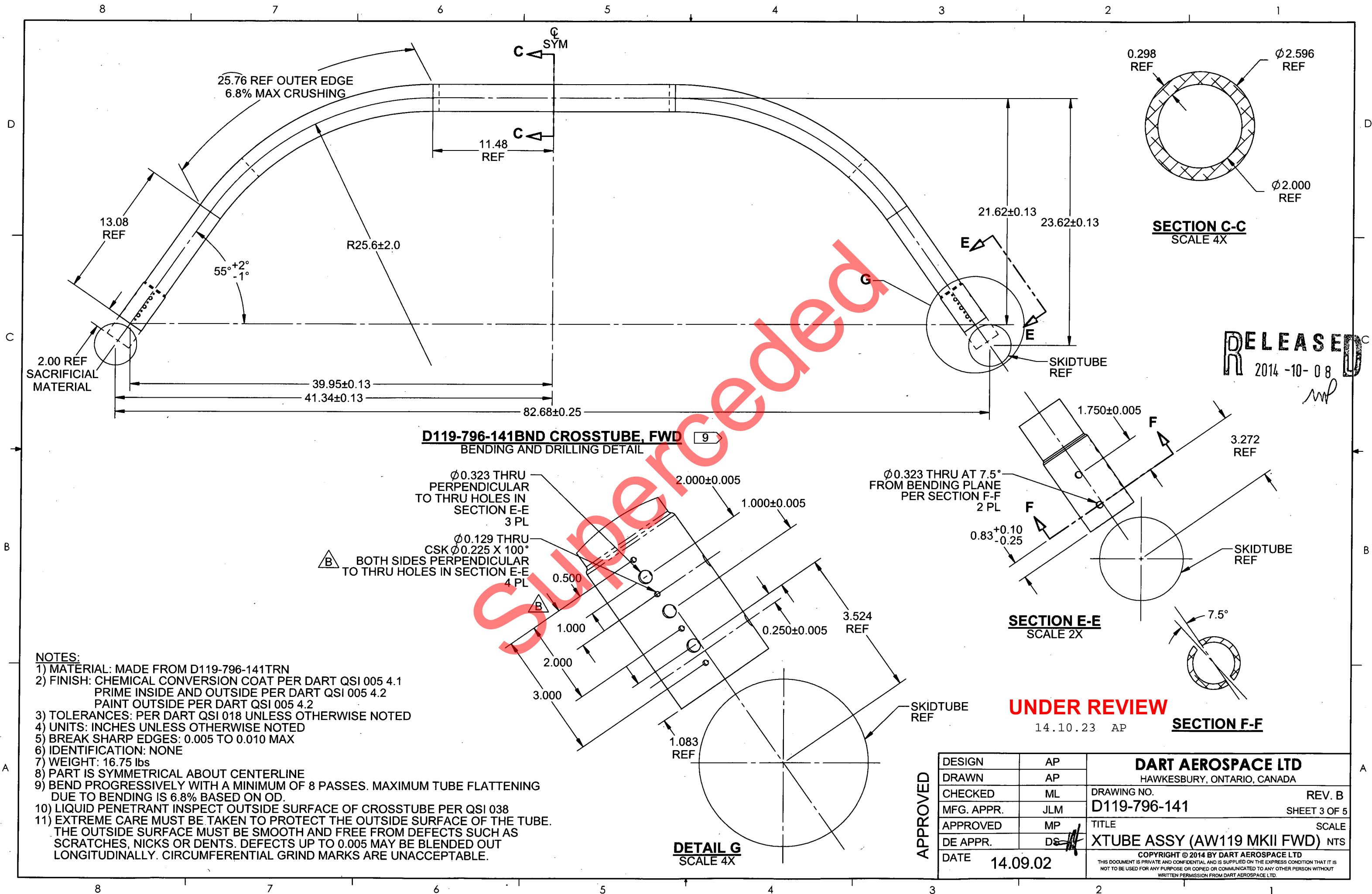
SECTION A-A
SCALE 2X

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[Signature]

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CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D119-796-141	SHEET 2 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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D119-796-141BND CROSSTUBE, FWD
BENDING AND DRILLING DETAIL

SECTION C-C
SCALE 4X

SECTION E-E
SCALE 2X

SECTION F-F

DETAIL G
SCALE 4X

- NOTES:**
- 1) MATERIAL: MADE FROM D119-796-141TRN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 16.75 lbs
 - 8) PART IS SYMMETRICAL ABOUT CENTERLINE
 - 9) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6.8% BASED ON OD.
 - 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038
 - 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

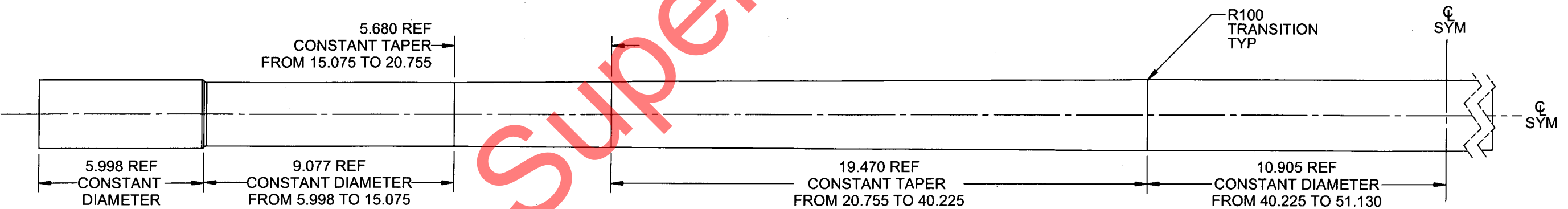
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DESIGN	AP
DRAWN	AP
CHECKED	ML
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.09.02

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D119-796-141	REV. B SHEET 3 OF 5
TITLE XTUBE ASSY (AW119 MKII FWD)	NTS
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D119-796-141TRN CROSSTUBE, FWD

UNDER REVIEW

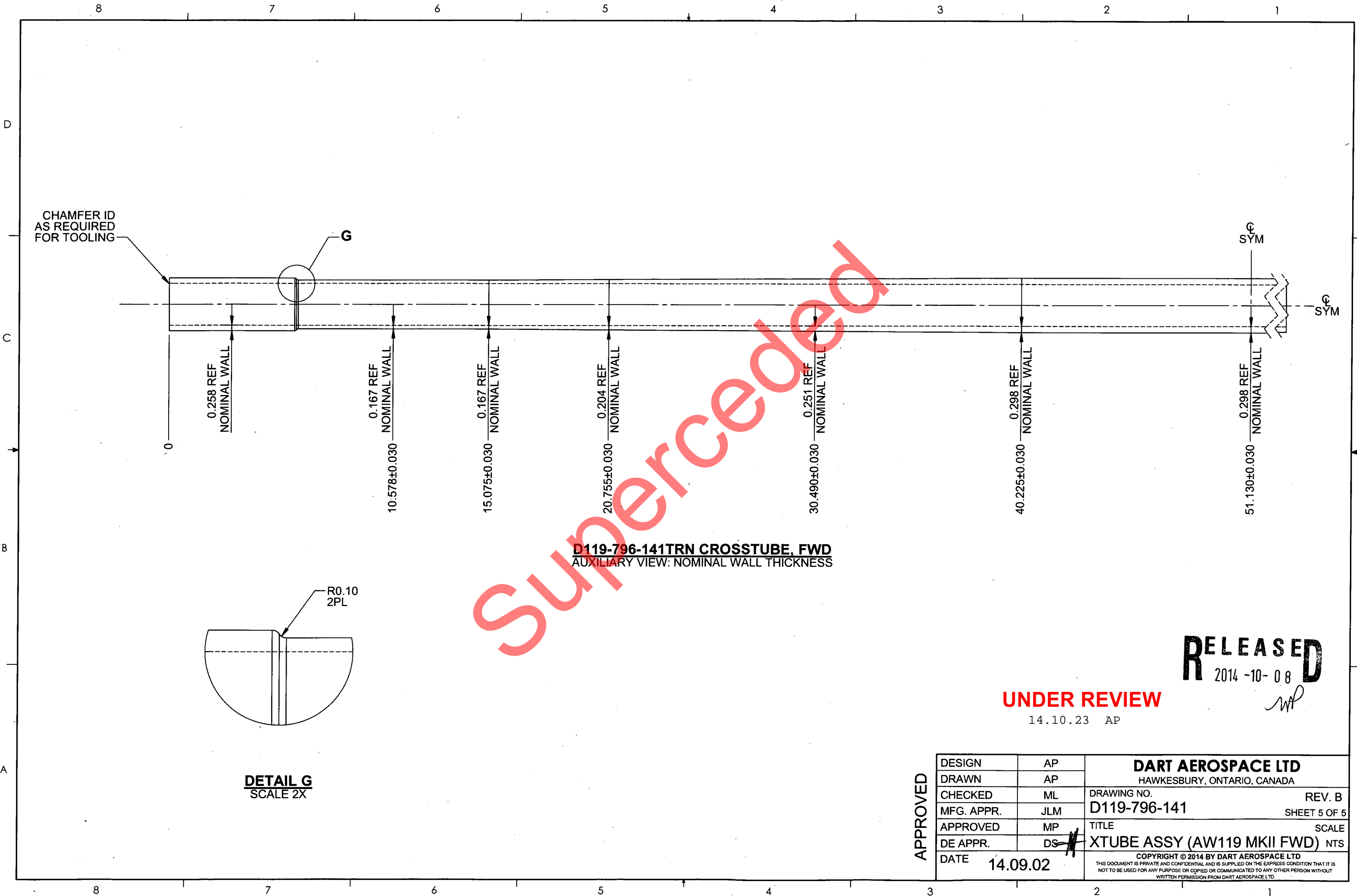
14.10.23 AP

RELEASED
2014-10-08

- NOTES:**
- 1) MATERIAL: MANUFACTURE FROM D6005-103
FINISHED LENGTH = 102.26 \pm 0.020 (BEFORE BENDING/TRIMMING)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 16.75 lbs
 - 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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DRAWN	AP		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D119-796-141	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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CHAMFER ID
AS REQUIRED
FOR TOOLING

G

Q
SYM

Q
SYM

0.258 REF
NOMINAL WALL

0.167 REF
NOMINAL WALL
10.578±0.030

0.167 REF
NOMINAL WALL
15.075±0.030

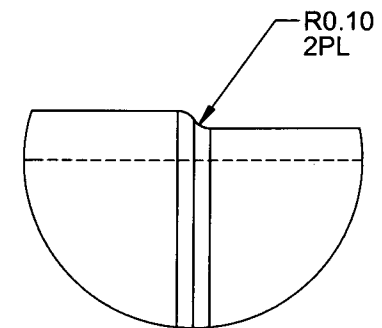
0.204 REF
NOMINAL WALL
20.755±0.030

0.251 REF
NOMINAL WALL
30.490±0.030

0.298 REF
NOMINAL WALL
40.225±0.030

0.298 REF
NOMINAL WALL
51.130±0.030

D119-796-141TRN CROSSTUBE, FWD
AUXILIARY VIEW: NOMINAL WALL THICKNESS



DETAIL G
SCALE 2X

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2014 -10- 08
MP

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14.10.23 AP

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DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ML	DRAWING NO. D119-796-141	REV. B
MFG. APPR.	JLM		SHEET 5 OF 5
APPROVED	MP	TITLE XTUBE ASSY (AW119 MKII FWD)	SCALE NTS
DE APPR.	DS		
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